

50

DART AEROSPACE LTD	Work Order:	21912
Description: Doubler	Part Number:	D3308-1
Dwg: D3308 Rev. A	Qty:	25
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	HJ	04.11.18	25
2	MV	Cut blank: 2.350" x 1.750" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3308-1 Batch: M16455	CPL	05-01-17	25
3	MV	Machine as per Folio FA473 and Dwg D3308 Stack of 10 Identify as D3308-1 HAND MADE BY GA	ml	05-02-21	25
4	QC2	Inspect parts as they come off the CNC machine	2	05-02-21	25
5	QC2	Second check			
6	GA	Deburr	ml	05-02-21	25
7	FP	Chemical Conversion Coat as per QSI 005 4.1	ml	05-02-21	25
8	QC3	Inspect Chemical Conversion Coat	ml	05-02-21	25
9	ST	Identify parts with batch number and part number using a fine point permanent marker as per Dwg D3308 and Stock	ml	05-02-21	25
10	AC	Cost / part: 3.00	Sgt	05.02.22	25
11	DC	Close W/O 2.78 Inspect Level 21	HJ	05.02.23	25

Rev	Date	Change	Revised By	Approved
A	04.11.18	New issue	KJ/JLM	

RELEASED
04/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

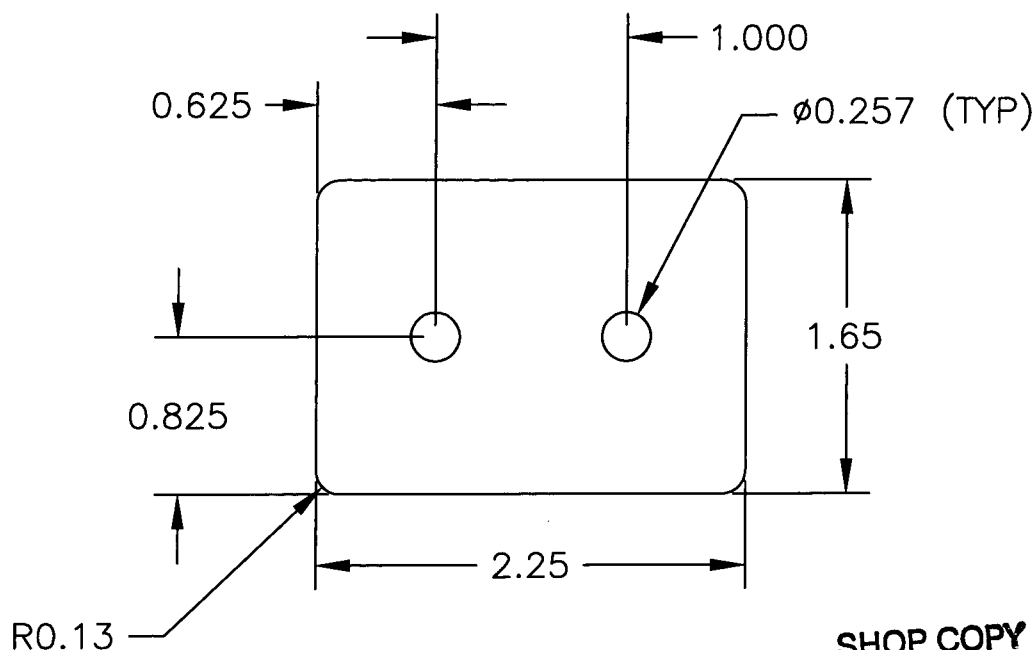
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3308	REV. A SHEET 1 OF 1
DATE 04.10.13	TITLE DOUBLER		SCALE 1:1
A	04.10.13	NEW ISSUE	



D3308-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21912

D3308-1 NOTES:

- 1) MATERIAL: 6061-T6 SHEET (QQ-A-250/11), 0.063 THICK
(REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2004
07:47 am

Work Order No : 0021912
Project Name : D3308-1
Project For : WK450
Work Order Type : Main
Main WO Number :
House Part Number : D3308-1
Description : Doubler
Manufactured : No
Amount Req'd : 10
Amount Done : 0
Start Date : 11-16-04
Est Finish Date : 12-04-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

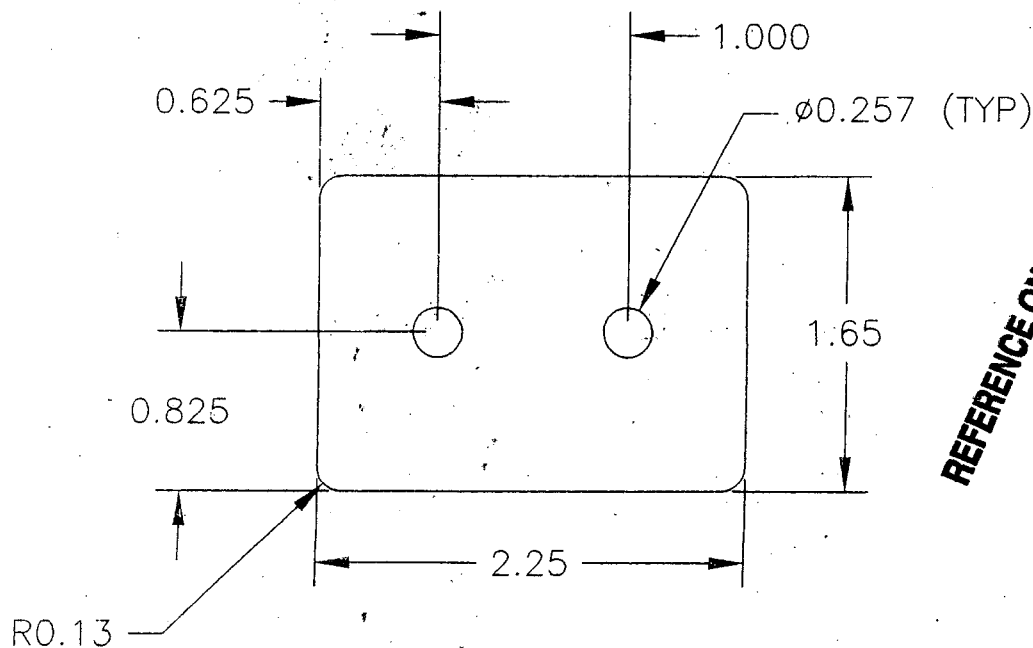
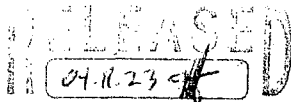
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

UNROLLED COPY

- 21912



DESIGN T1	DRAWN BY T1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3308	REV. A SHEET 1 OF 1
DATE 04.10.13		TITLE DOUBLER	SCALE 1:1
A	04.10.13	NEW ISSUE	



REFERENCE ONLY

D3308-1

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